PPG TrueFinish®
Industrial Coatings

SPECTRACRON® 300 SERIES 2K POLYURETHANE ENAMEL

DESCRIPTION:

SPECTRACRON® 300 SERIES 2K Polyurethane Enamel is a 2-component polyurethane with excellent exterior durability. It is recommended for industrial use on pretreated or primed metal surfaces for either interior or exterior use. Suitable applications include various metal fabrications castings, agricultural and construction equipment. Other substrates include plastics and fiberglass.

HIGHLIGHTS:

- Excellent color and gloss retention
- Available in wide range of colors and gloss
- Excellent mar resistance
- Contains no heavy metals

TECHNICAL PROPERTIES:

PROPERTY	METHOD	RESULT*
Color		Custom Colors
Gloss @ 60° Angle	ASTM D523	20 - 90
Pencil Hardness	ASTM D3363	F
Conical Mandrel	ASTM D522	Pass
Adhesion	ASTM D3359	5B
Humidity Resistance – 100 Hrs.	ASTM D2247	No blisters, 5B Adhesion
Salt Spray Resistance – 250 Hrs.	ASTM B117	Very Good
Chemical Resistance		Excellent Resistance to Acids. Very good solvent / gasoline resistance
Abrasion Resistance		Very Good
QUV-A 60° Gloss Retention – 500 Hrs.	D523	85 – 90%
Substrates		CRS, HRS, Alum, Galv, Plastics**, Fiberglass**
Recommended Primer(s)		SPECTRACRON: 135, 315, 501, 531, 560, 701, W43181A

*These results were obtained over iron phosphated CRS panels.

** Because of the variability of plastic/fiberglass substrates, coating performance should be confirmed on the actual plastic or fiberglass substrate being used.

PHYSICAL PROPERTIES:

PROPERTY	BLENDED VALUE*
Weight per gallon	8.6 ± 1.0 lbs./gal.
Weight Solids (%)	41.6 ± 5.0
Volume Solids (%)	38.5 ± 2.0
VOC (less exempts)	5.0 lbs./gal. (max.)
VOE (actual)	5.0 lbs./gal. (max.)
Flash Points:	
SPECTRACRON 300	63°F (17°C)
SPECTRACRON 3001	80°F (27°C)
Coverage (@ 1 mil, no loss)	618 – 682 sq. ft./gal.
Shelf Life - unopened container	QT300 - 4 years Q3001 - 2 years

*Blended values listed will be color dependent

Revision Date: 1/2011

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SURFACE PREPARATION:

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating will improve the performance properties of the coating system. See your PPG Representative for recommendations.

APPLICATION DATA:

Mixing Instructions:	7 parts SPECTRACRON 300 (QT300) : 1 part SPECTRACRON 3001 (Q3001) Mix by volume. Stir thoroughly prior to application.
Wet Film Thickness:	3.0 – 6.0 mils
Dry Film Thickness:	1.0 – 2.0 mils
Thinner:	Not recommended. Typical spray viscosity is 25 – 35" #3 EZ Zahn.
Clean up:	Q60 (MEK), Q30 (acetone) or Q120 (Polypurge)
Pot Life:	1-2 hours @ 77°F (25°C)

SPRAY APPLICATION	SPRAY EQUIPMENT*	FLUID PRESSURE (psi)	ATOMIZATION PRESSURE (psi)	FLUID NOZZLE	AIR NOZZLE
Conventional	Binks 2001	20 - 25	50	66SS (0.070", 1.8mm)	67PB
Conventional	DeVilbiss MBC-510	20 - 25	50	E (0.070", 1.8mm)	92
HVLP	DeVilbiss JGHV	20 - 25	50 - 55**	E (0.070", 1.8mm)	83MP

*or equivalent

**atomization pressure should read <10 psi @ the cap

CURE SCHEDULE:

Air-dry (assumes 77°F & 50% Relative Humidity)

To Touch:	30 – 60 min.
To Handle:	4 hrs.
To Recoat:	4 hrs. to 4 days

Bake / Force Cure

Flash Time:	10 min. (ambient)	
Substrate Temp:	120°F	or 140°F
Bake Time:	30 min.	20 min.

ADDITIONAL INFORMATION:

- Do not apply at temperatures below 50°F
- Excess film thickness will retard dry times and affect the recoat window
- After 4 days, mechanically abrade the surface before recoating
- In-Service Temperature: 300°F (As you approach 300°F depending on the pigmentation, the color may change, but the film integrity will be maintained up to 300°F.)
- Avoid moisture contamination with the B Component (Q3001) – moisture can gel the material and affect the performance properties

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